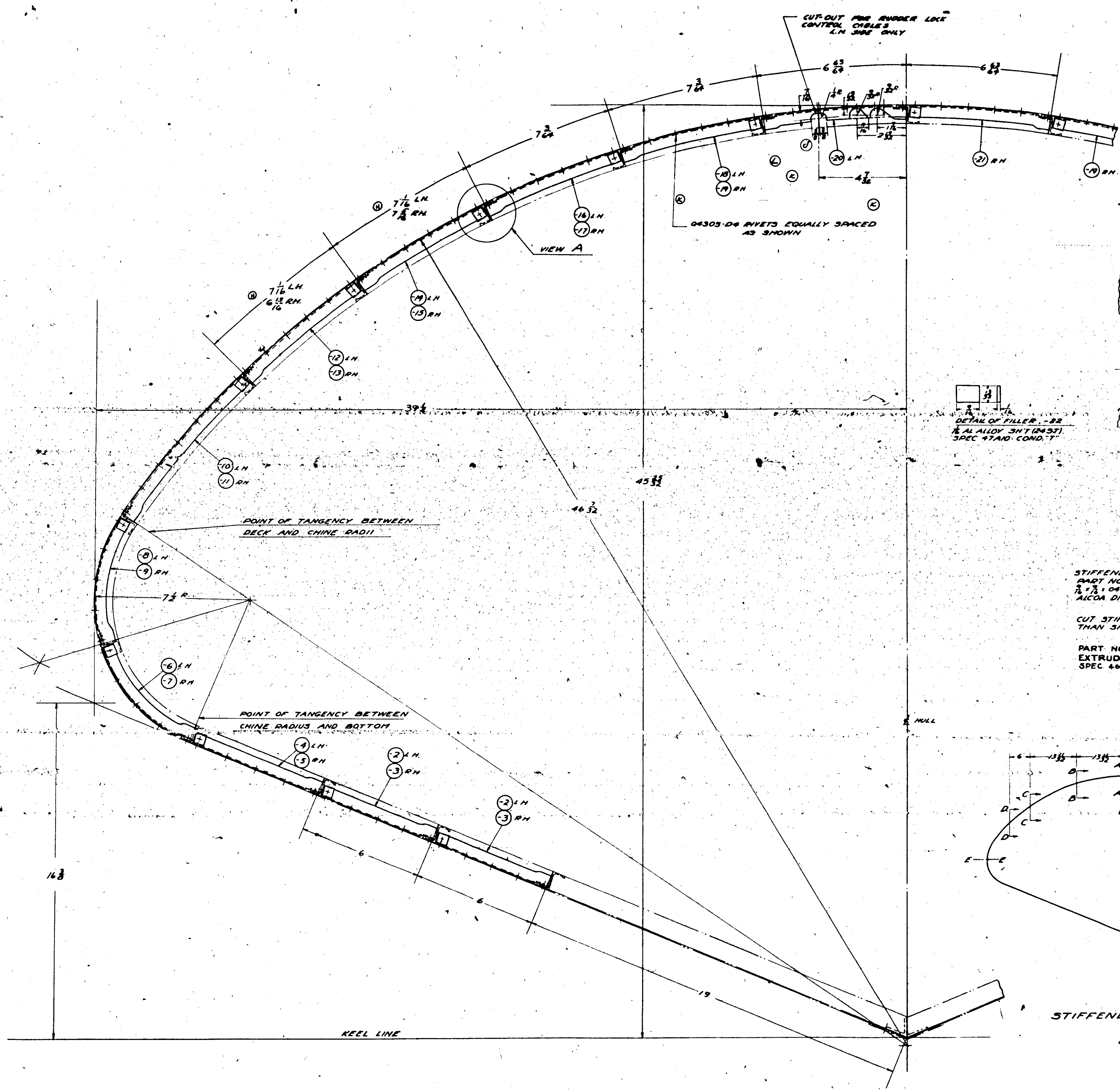
INCORPORATES
PBY-1 BU. AER. CHG. #131
PBY-2 " " #91

LET	ALTERATION	DATE	BY
G	TRACED UP TO DATE	5-20-37	[illegible]
H	CHANGED DIM ON -13E -15	5-7-37	[illegible]
J	ADDED CUTOUT IN -20 FOR RUDDER LOCK CONTROL CABLES (C.O.T891)	[illegible]	[illegible]
K	ADDED -23 REPLACING -20 ADDED -55 ASSEM. ADDED -24 -26 REPLACING -18 & -19	[illegible]	[illegible]
L	REMOVED -22 -24 -25 (E.O.38041)	[illegible]	[illegible]
M	-2,-3-4-5, CHANGED TO 24ST COND.T WAS 24SO COND A (E.O.A5251)	[illegible]	[illegible]



STIFFENERS
PART NO'S -6 TO -25 INCLUSIVE
5/8 x 5/8 x .040 ALUM ALLOY EXTR. ANGLE (24SO)
ALCOA DIE K-6240 SPEC 46A9 COND A - HT SP53 COND T

CUT STIFFENERS 1/4 LONGER THAN SHOWN AND FIT ON ASSEM.

PART NOS -2,-3-4-5. 5/8 x 5/8 x .040 ALUM. ALLOY EXTRUDED ANGLE (24ST) ALCOA DIE K6240 SPEC 46A9 COND T. (M)

SECTION	A-A	B-B	C-C	D-D	E-E
ANGLE	0°	0°	2°	4°	10°

STIFFENER INSTALLATION STA 7875
PORT SIDE
LOOKING FORW'D

FINISH:-
Z-P-GP ON XP3Y-1 & PBY-1
Z-P-GP ON PBY-2 & FUTURE (L)

DASH NO	MODEL	NEXT ASSY	REQ
-55	PBY-5A	28B1000	1
	28-5	28B1000	
-55	PBY-5B	28B6000	1
-56	PBY-5	28B1000	
	PBY-4	28B1000	
	PBY-3	28B1000	
	PBY-2	28B1000	
	PBY-1	28B1000	
	XP3Y-1	28B001	

REQUIREMENTS PER AIRPLANE

PARTS: 28B080-3, Q4305-D4, AN442-D4

PARTS LIST PER ASSY.

H 61

REPLACES
REPLACED BY
LIMIT ON DIMENSIONS UNLESS OTHERWISE SPECIFIED ± 1/32

APPROVED Y.PBJ DATE 5-20-37
CALC WT. .45 ACT WT
SCALE

NAVY NOTED MATERIAL
NOTED SPEC.
NOTED HEAT TREAT
NOTED FINISH

A.D. DRAFT CHECK EXAM

CONSOLIDATED AIRCRAFT CORP. BUFFALO, N.Y.
STAMP PT. No. WHERE SHOWN

NAME STIFFENER INSTALL HULL -STA. 7875

OPP. HAND

J 28B080